

Date: Friday, 12/9/2005 11:45:49 AM
 User: Kim Johnston

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 25184 - 1
 Estimate Number : 11348
 P.O. Number : N/A Part Number : D33397
 This Issue : 12/9/2005 S.O. No. : N/A Drawing Number : D3339 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : 12/9/2005 Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : N/A Material : N/A
 Due Date : 12/30/2005 Qty: 20 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est Rev:A New Issue 05-11-10 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: Issue P/O: 00000267 05/12/12
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg
 Possible supplier: Ind. Laser
 Material release note is required.

2.0 D33397F Wearpad



Comment: Qty.: 1.0000 U(s)/Unit Total : 20.0000 U(s)
 WEARPAD-FLAT

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necceray

2-Form as per Dwg D3339 using DT8326 and DT8261

DL 05/12/130 20
 SR 06/01/04 19

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25184

Part Number: D33397

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06.01.04 13

Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Hard coat 7560 per Dwg D3339, use DT8210 & DT8810 Layout Jig

CPL 06.02.14

13

A/R

7560 Hardcoat

Batch: M19174

~~06.01.04~~ 13

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/02/14 13

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9. m 06-03-10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13

13

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S7362

13/13

13

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/14

Job Completion



06.03.14

(13)



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 Glenbrook, South Auckland
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 (08) 235 8068 / 235 3535 Waikato
 Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 521

CUSTOMER	Wilkinson	P50323 D1001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC112397
CUSTOMER D/N	90-21N-686		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL Q/N	480737		DIMENSIONS	0.055" x 48" x Coil	DATE	09 June 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000											x10000	x100	180°			G.L.=	HRB	()	(feet)
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=45	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/8	(C)=C+Mn/8+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65? So (F)=8"	(B)=r90 (D)=(r0+r90+2r45)/4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Atish Misra*
 QC METALLURGIST

16 ga ms

POA 146, 267, 245,